

Date: Thursday, 15/05/2008 9:56:19 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
Job Number : 39283
Estimate Number : 13265
P.O. Number :
This Issue : 15/05/2008 S.O. No. :
Prsht Rev. : NC Part Number : D37781
First Issue : // Type : SMALL /MED FAB Drawing Number : D3778 REVA
Previous Run : 38601 Project Number : N/A
Material :
Due Date : 22/05/2008 Qty: 30 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A new issue 08-04-15 DD verified by:EC
Est Rev:B 08-05-14 revA as per ECN1171 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S090 5052-H32 .090 Sheet



Comment: Qty.: 0.0981 sf(s)/Unit Total: 2.9421 sf(s)
5052-H32 Aluminum sheet, 0.090" thick
Batch: 100782 IB 8-5-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3778

Dwg Rev: A

Prog Rev: A

****grain direction along 2.34" ****

2-Deburr if necessary

IB 8-5-20

IB 8-5-20



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/05/20



5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-deburr

2-Bend as per Dwg D3778

IB 08/05/22



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/05/2008 9:56:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39283

Part Number: D37781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/22 (31)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST2 48

ECN1171 D206-558-04/043

08/05/26 (31)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



B.1 Hand Finish

Chemical conversion

BR 08-05-23 (31)

B.2 Powdercoat

Black

QSI 005 4.3

M105642

Start time: 8:00 am

Oven temp.: 320 °F

Finish time: 8:30 am

M/K 08/05/26

(31X)

B.3 Qc 3

FZ 08/05/26 (31)

MF 08-05-26

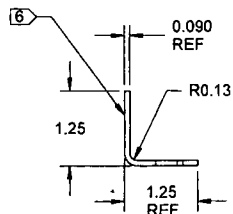
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

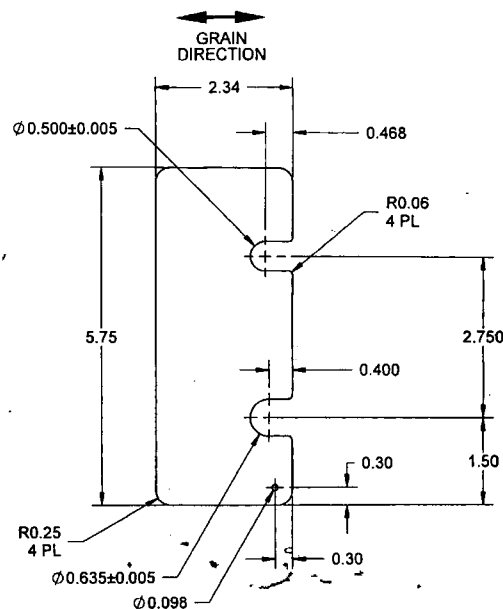
Part No: D3778-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 08/05/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>39283</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/23	5.0	one part scrap Bent in wrong orientation RC. Human error	PH QSI 042 08.05.23	QTY (X1) Scrap Destroy no Replace DOES NOT MATCH DSI 9412	SIB 08/05/23	C 08/05/23	PH QSI 042 08.05.23	C 08/05/23

NOTE: Date & initial all entries



D3778-1 BRACKET



D3778-1F FLAT PATTERN



W/O
39283

RELEASED
08-05-13

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090)
OR
6061-T6/T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-1" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.11 lbs.

REV.	NEW ISSUE	DESCRIPTION	PH	08.04.11
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH			
DATE	08.04.11			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3778	REV. A SHEET 1 OF 1
TITLE BRACKET	SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1941
1942
1943
1944
1945
1946
1947